

Work Order ID 77287

December-01-11 12:52:17 PM

77287

Page 1

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft Out 205
 Start Date: 01/12/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 21/12/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/01 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2573	Rev E								

100
100 HAAS CNC VERTICAL MACHINING #1 0.00
 HAAS 1
 HAAS CNC vertical machine #1
 Memo
 Program Batch No. 77287 Double check by: RL 1-Machine Step
 No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
 Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-
 Machine Step No 3 per Folio FA051 and insp
RL / RQ 11.12.23 12 ϕ

110
110 CONVENTIONAL MILLING MACHINE 0.00
 Mill Conv
 Conventional Milling Machine
 Memo
 Machine keyway as per dwg D2573 & D2574
RL / RQ 11.12.23 12 ϕ

120
120 QC2- Inspect parts off machine FAI/FAIB 0.00
 QC
 Quality Control
 Memo
RL / RQ 11.12.23 12 ϕ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77287

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Page 2

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft Out 205
 Start Date: 01/12/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 21/12/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	B.A	11/12/28		12	0		
--	---	--------------	-----	----------	--	----	---	--	--

140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	1A8	11-12-28		12			
---	---	--------------	-----	----------	--	----	--	--	--

150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							
---	--	--------------	--	--	--	--	--	--	--

START TIME: 8:50 FINISH TIME: 9:20 OVEN TEMPERATURE: 3200F

M119480

12X0 M/L 12/01/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77287

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Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft Out 205
 Start Date: 01/12/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 21/12/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3-Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: S1434	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

Handwritten signature

M.C.J. 12/01/02
12

CK 12/01/03

mf
12-01-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 77287

77287

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft Out 205

Start Date: 01/12/2011

Required Date: 21/12/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 1 As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-007		Manufactured	No			100	Each	21.0000	1	12			
D6101-007									**	29		11.12.13	

Saddle Billet

Location

Loc Qty

Loc Code

MAT042

10

71722 ✓

8

72228

2

MAT045

11

65383

1

65954

4

70680

6

76839 ✓

~~8~~ only 8 in system

~~4~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	77287
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.003	8.003	8.003		
F	0.490	0.510		.500	.502	.505	.502		
G	0.257	0.262		.259	.257	.257	.257		
H	0.375	0.380		.377	.375	.375	.375		
I	0.490	0.510		.500	.503	.503	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.567	.567	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.251	.251	.251		
S	0.115	0.135		.121	.128	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.234	.241	.241	.241		
W	0.115	0.135		.122	.130	.130	.130		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.50	.50	.50		
AB	0.615	0.635		.619	.622	.622	.622		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.242	.250	.250	.250		
AE	1.500	1.520		1.517	1.513	1.512	1.516		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.244	.244	.250	.250		
AI	2.000	2.020		2.008	2.004	2.003	2.006		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: RF
Date: 11.12.23

Audited by: B.A
Date: 11/12/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	77287
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	27	28		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.501	.503	.503	.503		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.502	.502	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.568	.569	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.251	.251	.250		
S	0.115	0.135		.129	.128	.130	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.228	3.229		
V	0.230	0.250		.239	.239	.239	.240		
W	0.115	0.135		.123	.123	.123	.130		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.364	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.619	.619	.619	.619		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.249	.249	.249		
AE	1.500	1.520		1.511	1.515	1.515	1.512		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.270	.270	.275		
AH	0.240	0.260		.249	.249	.249	.250		
AI	2.000	2.020		2.0015	2.0015	2.002	2.0025		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	cmf
Date:	11/12/24

Audited by:	BA
Date:	11/12/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	77287
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#9	#10	#11	#12		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.7500	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.124	.125	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.129	.129	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.239	.239	.239	.239		
W	0.115	0.135		.123	.123	.123	.123		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.364	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.619	.619	.619	.619		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.249	.249	.249		
AE	1.500	1.520		1.511	1.511	1.511	1.512		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.249	.249	.249	.249		
AI	2.000	2.020		2.002	2.002	2.002	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	RF
Date:	11.12.27

Audited by:	K.A
Date:	11/12/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

~~SUBJECT TO AMENDMENT~~

NO. 77287

05.12.06

MATERIAL: 7075-T7351 (QQ-A-250/12)

(REF DART SPEC. D6102-001)

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
PART 001 005 1.3

DART QSI 005 4.3
BREAK ALL CHAIR EDGES 2.2

BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010

2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015
WITH MIN RAD 0.125

CHAMFER 0.063" x 45° AROUND THIS SURFACE
(TYPICAL 2 PLACES)

CHAMFER 0.063" x 45° ALL AROUND

CHAMFER 0.033" x 45° (SEE DETAIL C)

Technical drawing of a mechanical part. The drawing shows a cross-section of a part with a central hole. The dimensions and tolerances are as follows:

- Overall width: 1.73
- Central hole diameter: $\varnothing 0.50$
- Top fillet radius: R0.50
- Bottom fillet radius: R0.50
- Bottom hole diameter: $\varnothing 0.50$

0.20 2 (1P)

PART

[illegible]

— 3.500±0.005 —————→ 1.750
±0.005 —————→

8.000

3.07.13	ADD CHAMFER ON RIDGE NOTE 5
3.08.06	ADD RIDGES: TIGHTEN TOLERANCES

2-09-88	ADD RIDGES, TIGHTEN TOLERANCES
2-13-88	INCRP. DEF. 9123/9079/9102

9.10.22	ADD DIMENSIONS PER TSR A1177
---------	------------------------------

6.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
---------	---------------------------------

6.09.16	NEW ISSUE	
OWN BY		DATE APPROVAL LED

PH **DART** DART AEROSPACE LTD.
MARKESBURY, ONTARIO, CANADA


REV. E
DRAWING NO. D2573
SHEET 1 OF 1

TITLE	SCALE
QUICK SET CARRIAGE	

OUTER AFT SADDLE 2:1

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DART AEROSPACE LTD.

DESIGN	DRAWN BY	 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
DS	PH		
CHECKED 	APPROVED 	DRAWING NO.	REV. E
		D2573	SHEET 1 OF
DATE		TITLE	SCALE
05.07.13		OUTER AFT SADDLE	2:1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 77287 M.L.5

RELEASED

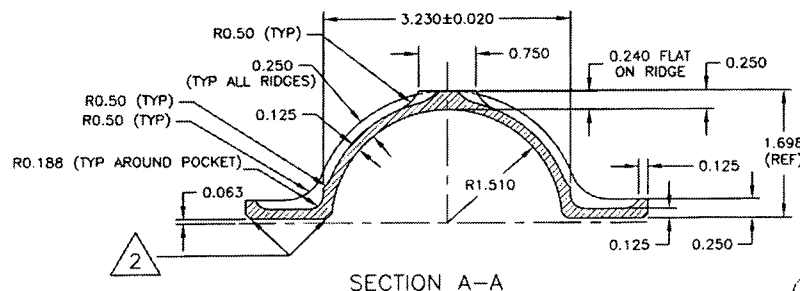
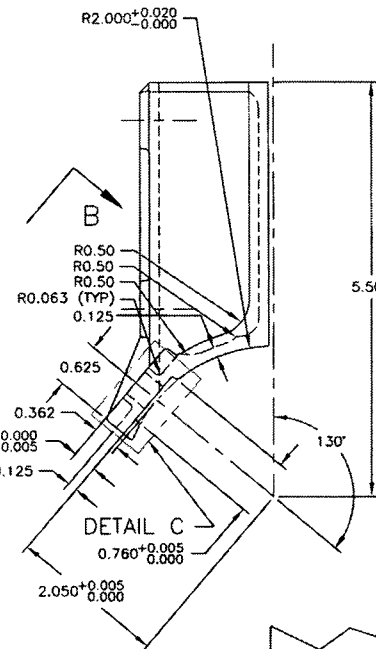
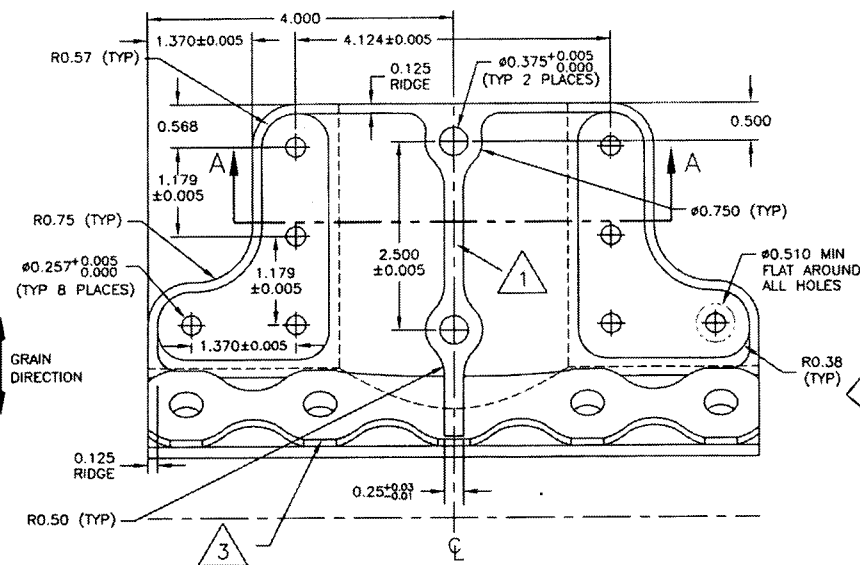
11/12/01

05.12.06

NOTES

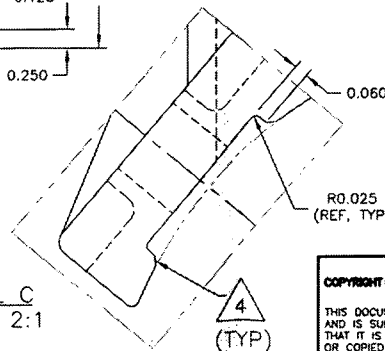
MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



SECTION A-A

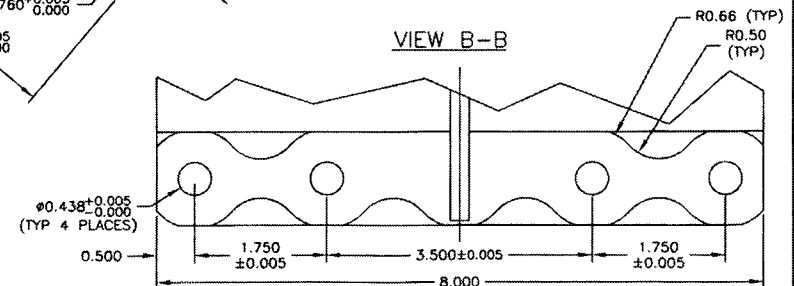
DETAIL C
SCALE 2:1



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OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	05.07.13	DRAWING NO. D2574
		TITLE INNER AFT SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

DART DART AEROSPACE LTD.
HARRISBURG, ONTARIO, CANADA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries